

Work Order ID 64906-2

Wednesday, December 22, 2010 2:57:21 PM

Page 1

Item ID: D350-591-311

Accept

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010 Start Qty: 5.00

Required Date: 1/24/2011 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date: 10/22/22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002

110

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☐ M102436  
M115928

3-Grind End Plate flush

for CL 11/01/10

Tool L  
Europe Subcity

11.01.06 5  
10 P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 64906



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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 ~~0~~ BE 11/10/10

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 n10/107

(x5  
41)

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=) 4 11/10/10

(Y5LH)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*11.01.11*

5

*φ*

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod *M108436*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

*11.01.11*

5

*φ*

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Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

5 0 BE 11/0/12

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulaluz



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

5 LH BR 11-a-12.

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M115951

Memo

0.00

START TIME: 3:35

OVEN TEMPERATURE: 320°

FINISH TIME: 4:05

5LH BR 11-01-12

230



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M115790

0.00

Memo

0.00

5LH 11/01/13

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8/11/14

5LH

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

11/13 SP (58)

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

Subby

x5

44

270



Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify and pack for shipping as per PPPD350-591-311  
Location: New B

12/14/10 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Revision ID:

Stop



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Start Date: 12/22/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 1/24/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/17

11-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, December 22, 2010 2:57:27 PM

Page 1

Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH





Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3272-1 JLM  
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC  
 IPP Rev:D fix route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 		Manufactured	No			110	Each	0.0000	1	5			
Step													
D3067-1 		Manufactured	No			110	Each	116.0000	1	5			
End Plate													
<div> <div>Location</div> <div>WA</div> <div>60141</div> <div>62664</div> <div>63550</div> </div> <div> <div>Loc Qty</div> <div>116</div> <div>2</div> <div>6</div> <div>108</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
D3219-1 		Manufactured	No			110	Each	113.0000	2	10			
Plate													
<div> <div>Location</div> <div>WA</div> <div>63551</div> </div> <div> <div>Loc Qty</div> <div>113</div> <div>113</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3066-1 		Manufactured	No			180	Each	86.0000	2	10			
Spacer													
<div> <div>Location</div> <div>WA</div> <div>63549</div> </div> <div> <div>Loc Qty</div> <div>86</div> <div>86</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

11.03.03 364911

11.01.06

11.01.06

11.01.11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Appr QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, December 22, 2010 2:57:27 PM

Work Order ID: 64906

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

MS20600-AD4W4

Purchased

No

180

Each

2,351.000

16

80



Rivets



*11.01.11*

## Location

## Loc Qty

## Loc Code

ST321

2351

113368

38

114181

11

114718

2

115573

147

115640

31

116022

622

116188

1500

*80*

D3065-041

Manufactured

No

180

Each

42.0000

1

5



Step Leg Assembly Hi



*11.01.11*

## Location

## Loc Qty

## Loc Code

WA

42

63324

2

63555

40

*5*

D3067-1

Manufactured

No

180

Each

116.0000

1

5



End Plate



*11.01.11*

## Location

## Loc Qty

## Loc Code

WA

116

60141

2

62664

6

63550

108

*5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 64906

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Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased

No

250

Each

118.0000

2

10



Bolt



m116549 11/13/10

Location

Loc Qty

Loc Code

ST353

118

116191

100

116419

18

D3235-1

Manufactured

No

250

Each

61.0000

2

10



Mounting Lug



11/13/10

Location

Loc Qty

Loc Code

ST471

61

61845

1

63547

60

D3278-041

Manufactured

No

250

Each

8.0000

1

5



Support Assembly



B63553 11/13/10

Location

Loc Qty

Loc Code

ST460

8

64731

8

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

30.0000

16

80



Washer



m116304 11/13/10 st

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

Wednesday, December 22, 2010 2:57:27 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

34.0000

4 20



Washer



m114742 - 10/1/350

## Location

## Loc Qty

## Loc Code

ST

34

103694

18

107534

12

109287

4

AN5-36A

Purchased

No

250

Each

101.0000

2 10



Bolt



11/1/350

## Location

## Loc Qty

## Loc Code

ST341

101

114292

1

116191

100

D2618

Manufactured

No

250

Each

36.0000

2 10



Bushing



11/1/350

## Location

## Loc Qty

## Loc Code

ST019

36

63548

36

D2230-3

Manufactured

No

250

Each

94.0000

4 20



Lug



11/1/350

50

## Location

## Loc Qty

## Loc Code

ST476

94

55452

2

63312

12

64422

80

20

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Shop Packet Print

Page 4

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/22/2010

Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

275.2930 1.2



Abraison Strip



11/11/350

## Location

## Loc Qty

## Loc Code

ST403

275.2930421

56626

0.00004211

59920

59.293

63735

216

5x  
5x

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

MS21042L3

Purchased No

250 Each

1,870.000

2 10



Nut



11/11/350

## Location

## Loc Qty

## Loc Code

ST300

1870

114784

9

115835

957

116373

4

116391

900

10

AN4-13A

Purchased No

250 Each

274.0000

8 40



Bolt



11/11/350 150

## Location

## Loc Qty

## Loc Code

ST357

274

116191

274

40

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Shop Packet Print

Page 5

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Required Date: 1/24/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

1,199.000

2

10



Nut



11/1/13 SP

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

1173

115156

5

115594

500

116104

172

116105

496

10

MS21042L4

Purchased

No

250

Each

4,242.000

8

40



Nut



11/1/13 SP

Location

Loc Qty

Loc Code

ST300

4242

1123143

2

115589

10

115621

730

116188

3500

40

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

8.0000

4

20



Washer



11/5/12 11/1/13 SP SP

Location

Loc Qty

Loc Code

ST

6

107715

6

ST335

2

105792

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED***07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *04906*  
*BS 10222*

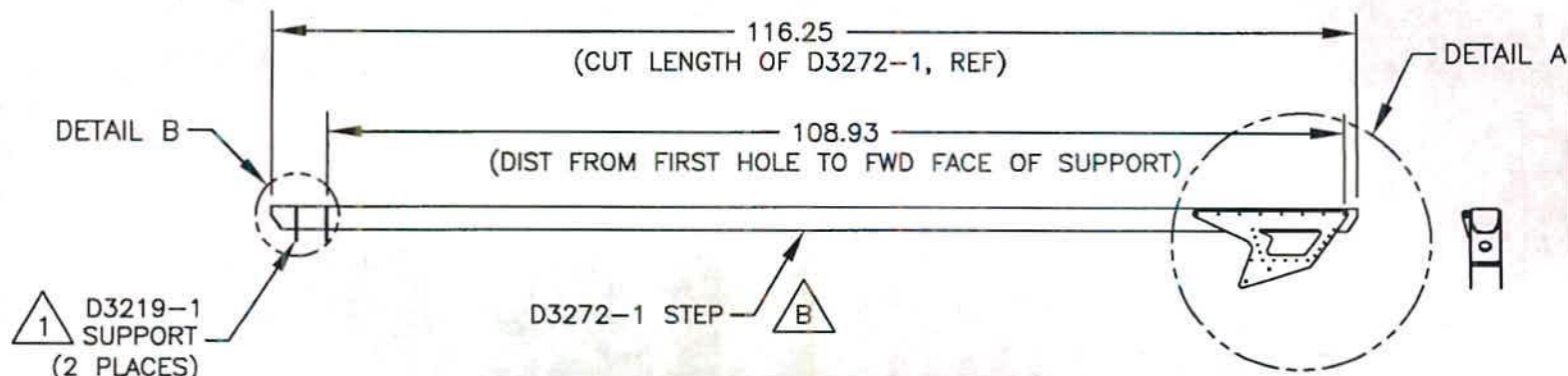
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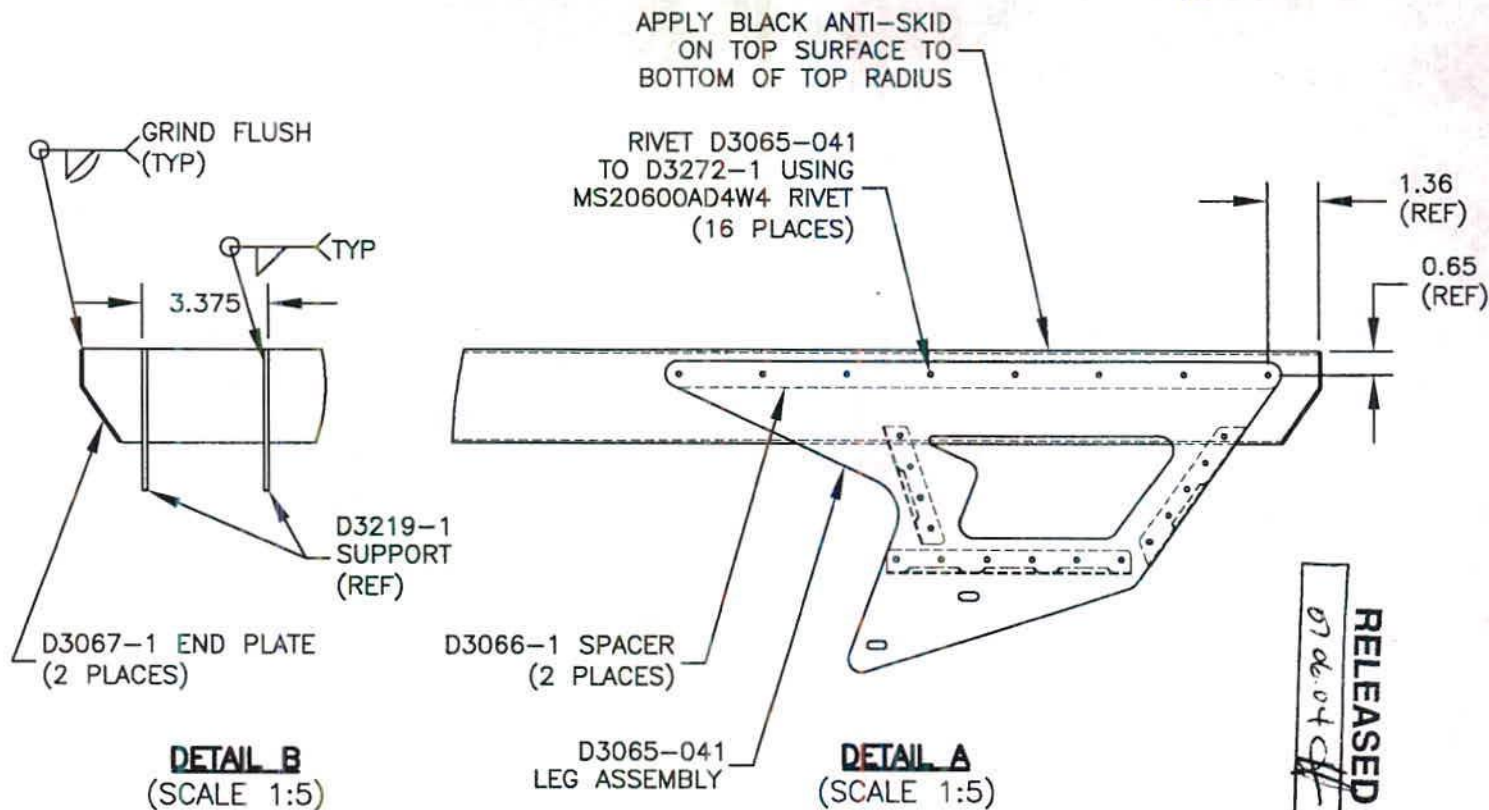


**DART**

DESIGN	40	DRAWN BY	AS	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	AS	DRAWING NO.
				D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
				SHEET 2 OF 3
				SCALE
				1:20



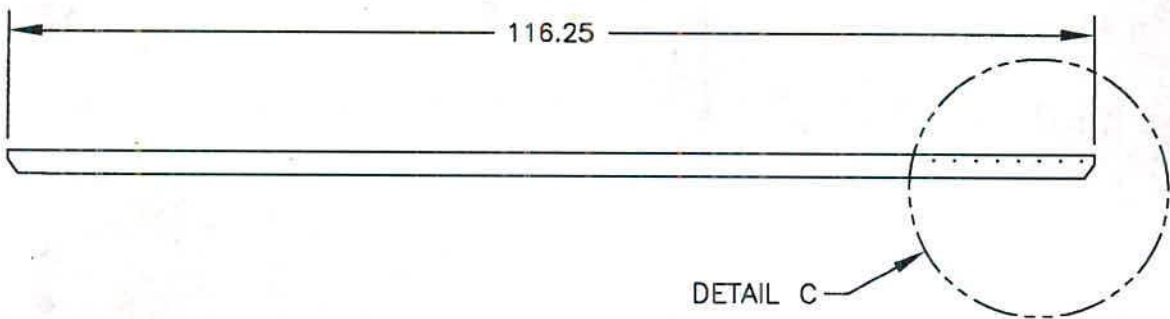
**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**





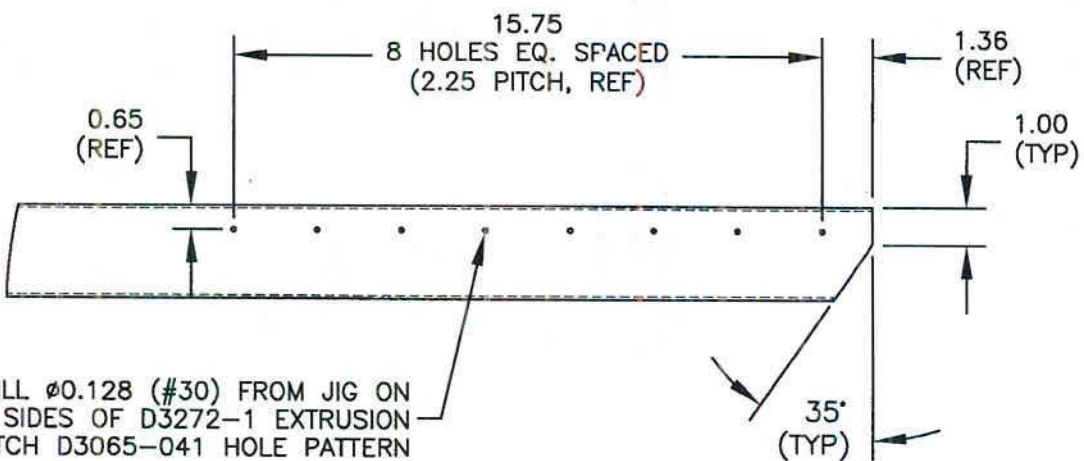
**DART**

DESIGN	qf	DRAWN BY	JR	DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 3
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



**B** **D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)

*w/064904*



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

**RELEASED**  
*07.06.04*

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.